

Date: Monday, 02/06/2008 8:11:12 AM
 User: Jean-Luc Menard

Split -2
Process Sheet

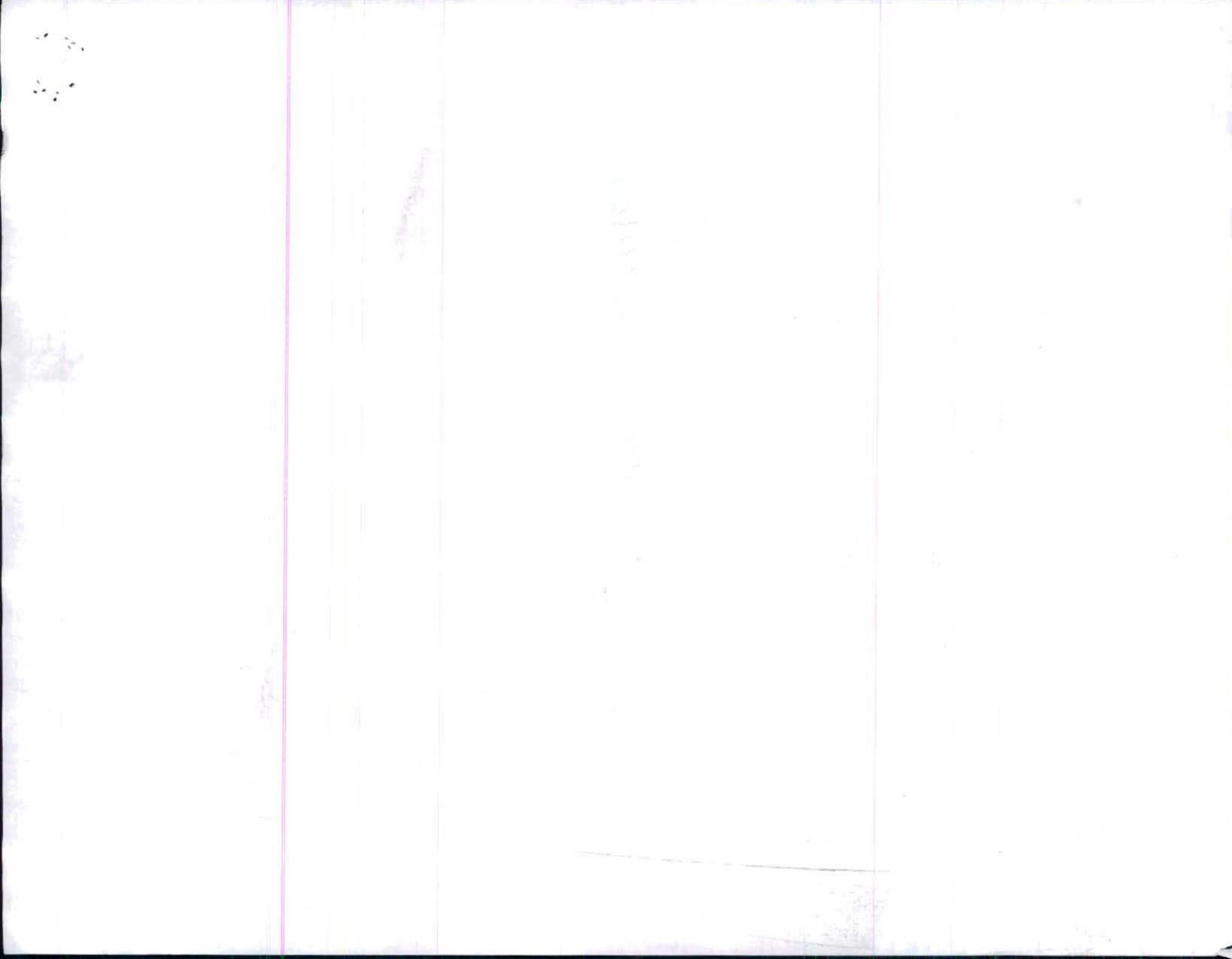
Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	INNER AFT SADDLE		
Job Number	39621 -2			Part Number	D5957		
Estimate Number	11082			Drawing Number	D5957 REV B		
P.O. Number	:			Project Number	N/A		
This Issue	02/06/2008	S.O. No. :		Drawing Revision	B		
Prsht Rev.	NC			Material	:		
First Issue	11	Type	MACHINED PARTS	Due Date	09/06/2008	Qty:	7
Previous Run	39606					Um:	Each
Written By	<i>JLM</i>						
Checked & Approved By	<i>JLM 06.02</i>						
Comment	Est Rev:E	Re-Format	05-11-29 JLM				
	Est Rev:F	ecn826	06.12.06 ec				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) D6101-007(7075-T7351) Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: 34875	(7)
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3	
		Comment: HAAS CNC VERTICAL MACHINING #3 1-Machine as per folio D5957, Ensure Batch Number is entered 2-Machine Keyway 3-Deburr & Tumble	DTP 08/06/03 8.F 08/06/02
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	DTP 08/06/03
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	R 08/06/05 L 08/06/02
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	20/BK 08-06-05



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 39621

Part Number: D5957

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M107925



(TA)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:00
01=

OVEN TEMPERATURE:

320

FINISH TIME:

9:30

M-F 08/06/09

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(FL 08/06/09)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 421

(AS 08/06/09 X7)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/10 (H)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

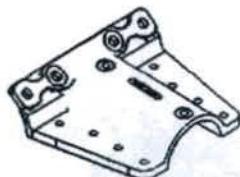
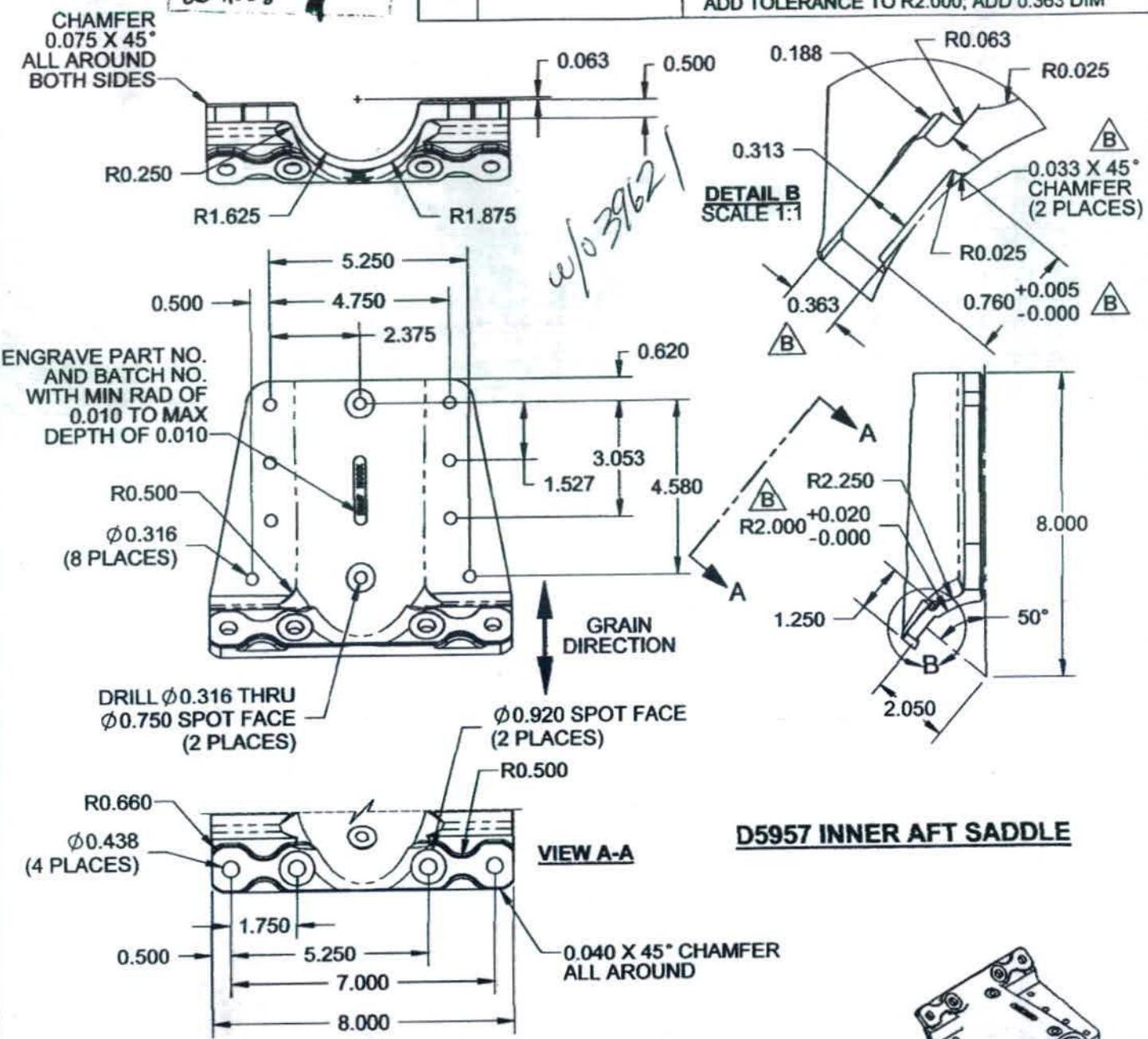


C 208/06/09



DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D5957	REV. B SHEET 1 OF 1	
DATE 06.11.07		TITLE INNER AFT SADDLE	SCALE 1:4	
REV A	DATE 97.05.06	DESCRIPTION		
B	06.11.07	NEW ISSUE INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM		

~~RELEASER~~06.11.07 *[Signature]*

ISOMETRIC VIEW
SCALE 1:8

NOTES:
1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3

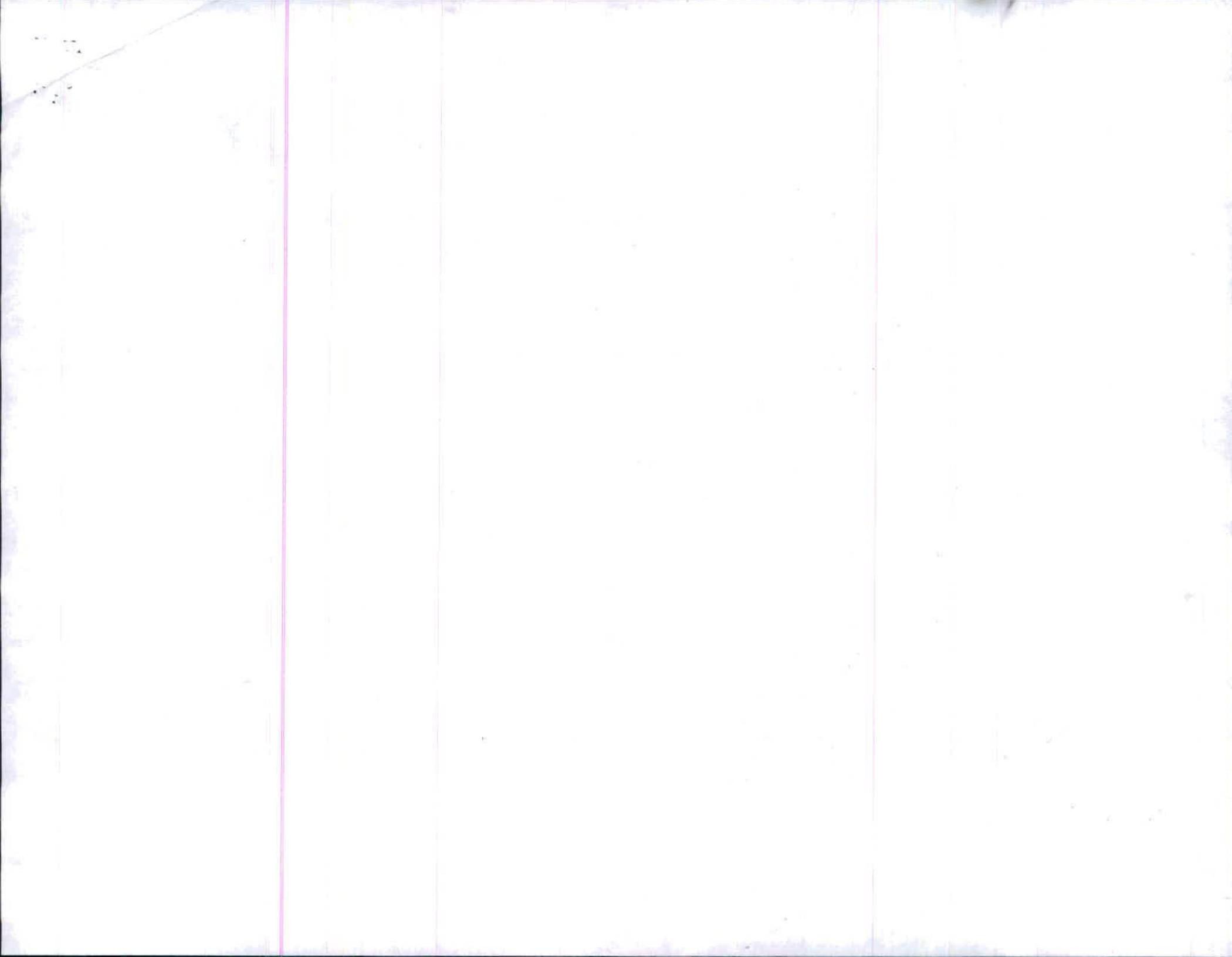
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DART AEROSPACE LTD

Work Order:

39621

Description: Inner Aft Saddle

Part Number:

D5957

Inspection Dwg: D5957

Rev: B

Page 1 of 1

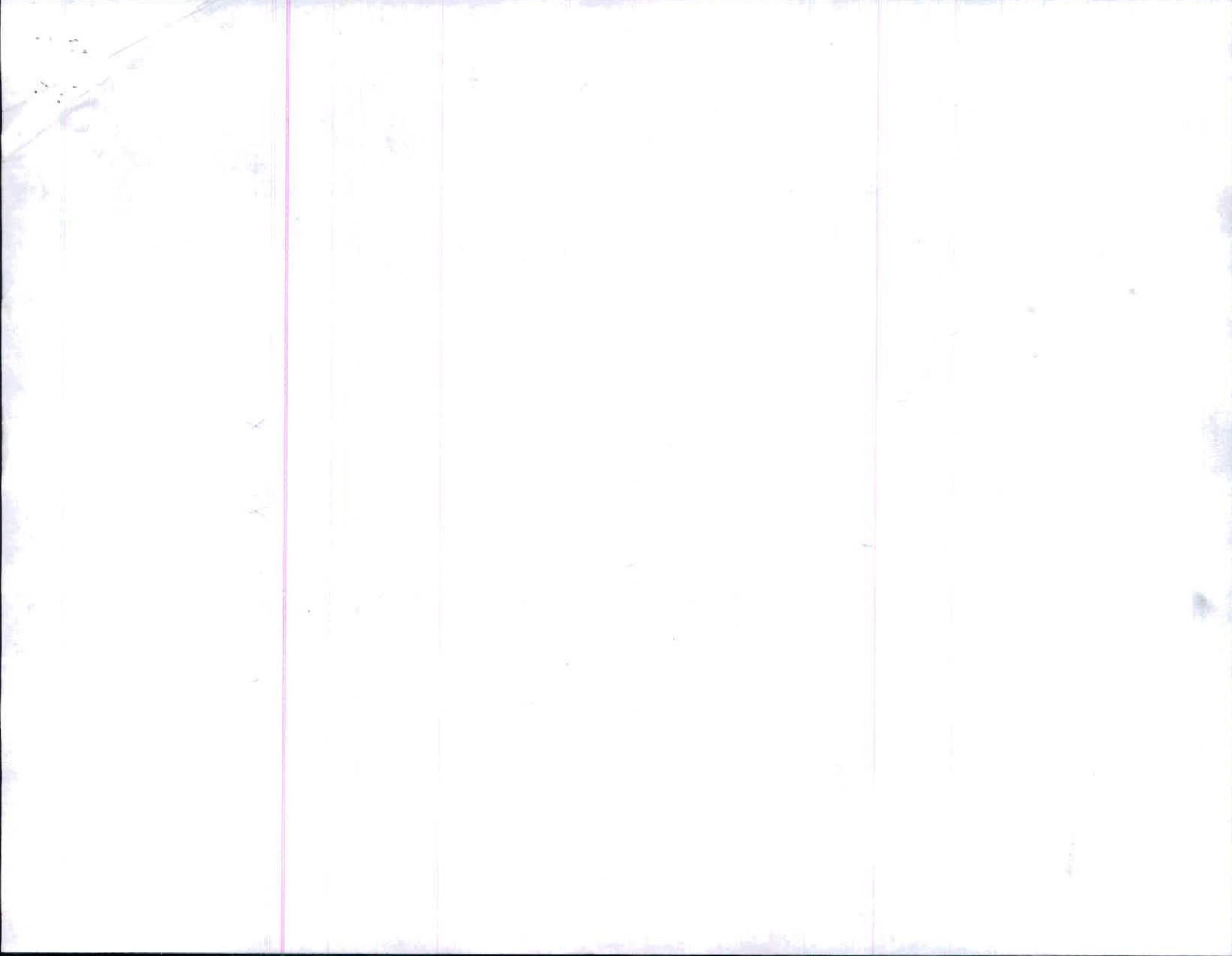
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	X	1X	2X	3A	By	Date
A	0.438	0.443		.442			0.442	0.442	
B	1.745	1.755		1.744			1.7485	1.749	
C	5.245	5.255		5.248			5.250	5.250	
D	6.995	7.005		6.998			6.997	6.998	
E	5.240	5.260		5.250			5.250	5.250	
F	4.745	4.755		4.750			4.750	4.750	
G	0.315	0.322		.319			.320	0.322	
H	1.522	1.532		1.527			1.527	1.527	
I	3.048	3.058		3.052			3.050	3.053	
J	4.575	4.585		4.580			4.580	4.580	
K	0.313	0.318		.318			.318	0.318	
L	0.495	0.505		.500			0.500	0.500	
M	0.490	0.510		.503			.503	0.503	
N	1.865	1.885		1.875			1.885	1.885	
O	7.990	8.010		8.001			8.000	8.000	
P	2.240	2.260		2.250			2.250	2.250	
Q	0.307	0.312		.310			0.310	0.312	
R	0.760	0.765		.761			0.760	0.760	
S	0.490	0.510		.499			0.502	0.508	
T	1.625	1.645		1.634	1.6335	1.633	1.6336		
U	2.000	2.020		2.007			2.006	2.006	
V	0.023	0.043		.033			0.033	0.033	
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject				Reject					

Measured by: SF / DTP
 Date: 08/06/02 / 08/06/03

Audited by: *[Signature]* Date: 20/06/02

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>



DART AEROSPACE LTD

Work Order:

39621

Description: Inner Aft Saddle

Part Number:

D5957

Inspection Dwg: D5957

Rev: B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	4	5	6	7	By	Date
A	0.438	0.443		0.442	0.442	0.442	0.442		
B	1.745	1.755		1.748	1.749	1.750	1.750		
C	5.245	5.255		5.249	5.250	5.249	5.250		
D	6.995	7.005		7.001	7.001	7.009	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.7485		
G	0.315	0.322		0.322	0.322	0.322	0.322		
H	1.522	1.532		1.527	1.527	1.527	1.525		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		0.318	0.318	0.318	0.318		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.503	0.502	0.503	0.501		
N	1.865	1.885		1.885	1.880	1.880	1.8785		
O	7.990	8.010		7.999	7.999	7.999	7.999		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.493	0.493	0.495	0.495		
T	1.625	1.645		1.632	1.632	1.6335	1.6325		
U	2.000	2.020		2.003	2.003	2.004	2.004		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:

DJP

Date: 08/06/03

Audited by:

RJ
08/06/03

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	BB

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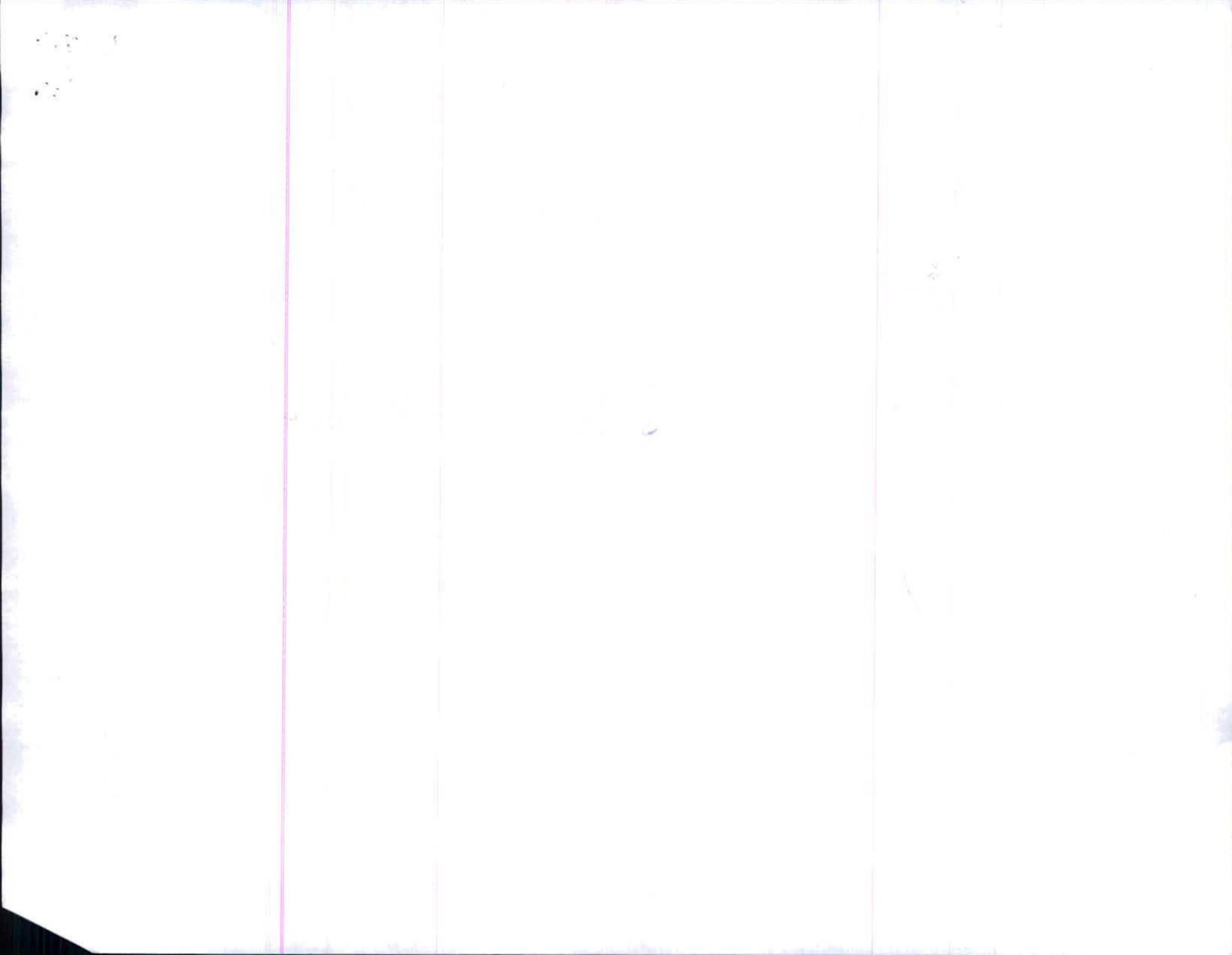
DART AEROSPACE LTD	Work Order:	39627
Description: Inner Aft Saddle	Part Number:	D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	8	2	3	4	By	Date
A	0.438	0.443		0.442					
B	1.745	1.755		1.748					
C	5.245	5.255		5.250					
D	6.995	7.005		7.001					
E	5.240	5.260		5.250					
F	4.745	4.755		4.7485					
G	0.315	0.322		0.322					
H	1.522	1.532		1.526					
I	3.048	3.058		3.052					
J	4.575	4.585		4.580					
K	0.313	0.318		0.318					
L	0.495	0.505		0.500					
M	0.490	0.510		0.503					
N	1.865	1.885		1.880					
O	7.990	8.010		8.000					
P	2.240	2.260		2.250					
Q	0.307	0.312		0.303					
R	0.760	0.765		.710					
S	0.490	0.510		0.495					
T	1.625	1.645		1.635					
U	2.000	2.020		2.005					
V	0.023	0.043		0.033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	DAP	Audited by:	PP/6/05
Date:	08/06/03	Date:	08/06/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	BB

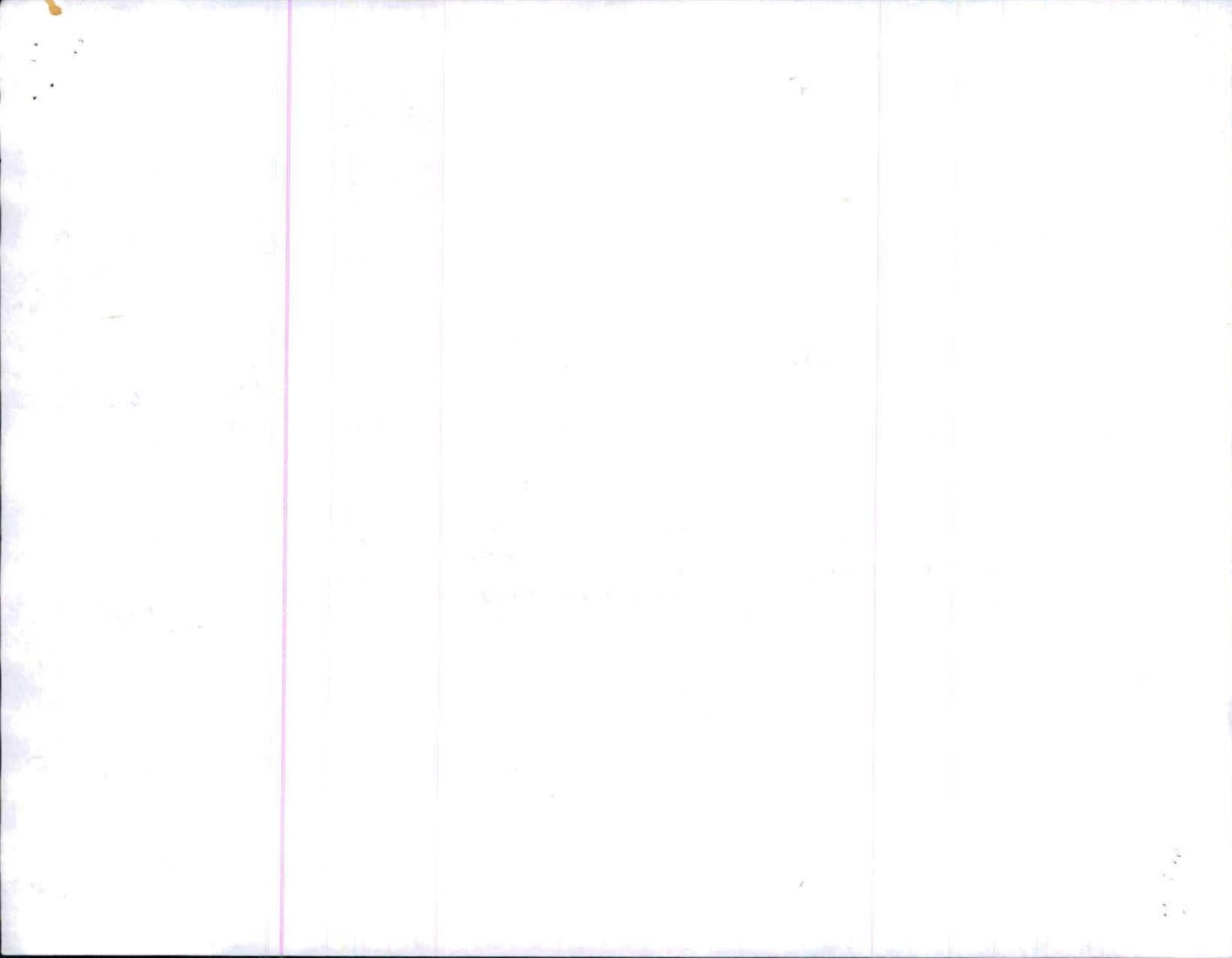


W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5957 PAR #: N/A Fault Category: Prod/Machin. Rpt. NCR: Yes No DQA: D Date: 08/06/12
 QA: N/C Closed: SJ Date: 08/06/13

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/13	2.0	instal the Saddle incorrectly on the 4 axis.	J DSR	-Add note to Fols to clarify hole location. See attached Scrap: Replace QTY 1 Batch # <u>34875</u>	08/06/03 DSR	J 08/06/10	J 08/06/12	J 08/06/13

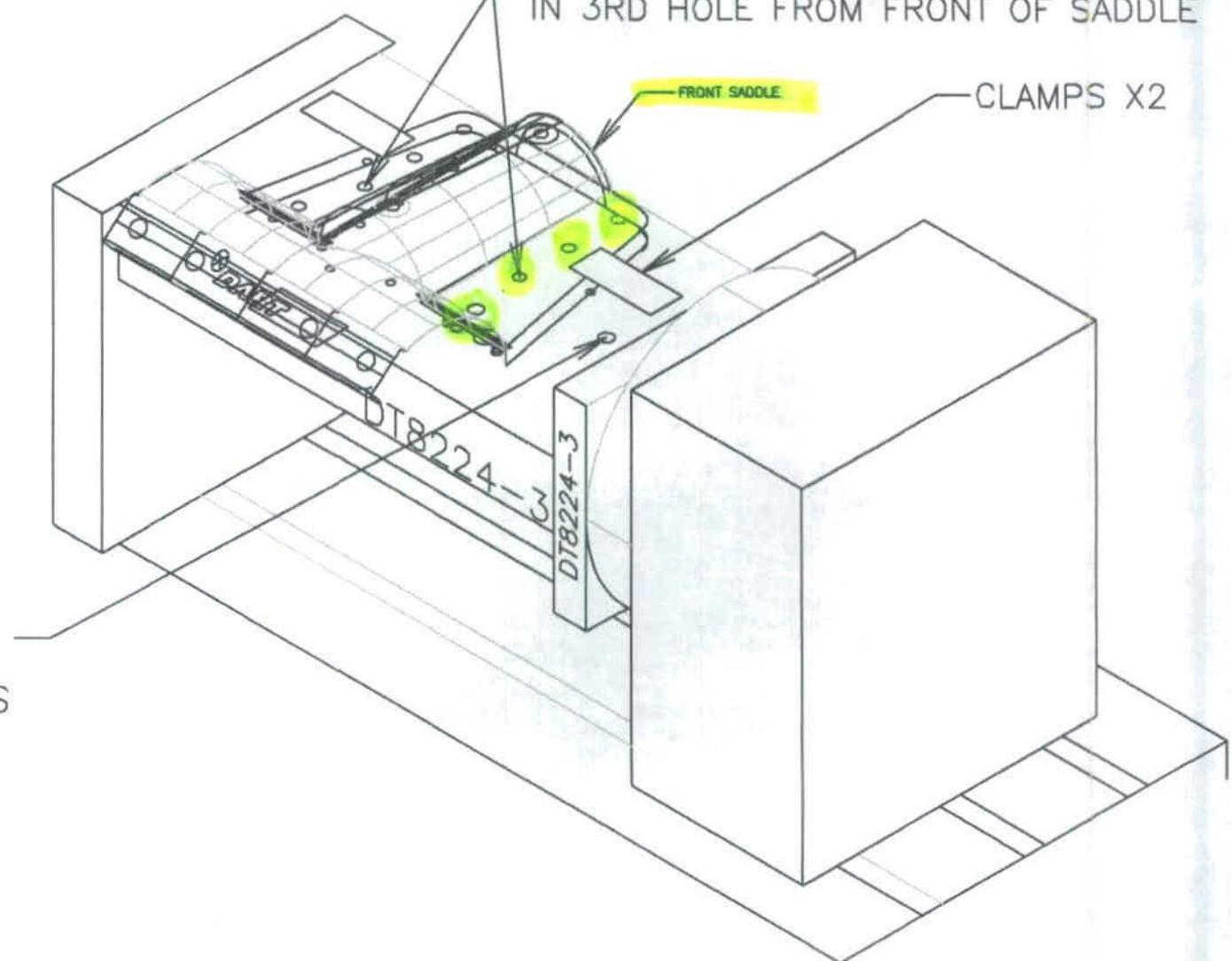
NOTE: Date & initial all entries



D5957 HIHI SADDLE 4TH OP

PROG #4007

LOCATE WITH 2X 5/16" DOWELS
IN 3RD HOLE FROM FRONT OF SADDLE



G110:

X=9.0

Y=0.0

Z=0.0 CENTER OF AXIS

